

# Work Order ID 86048

June-19-12 4:11:02 PM

**\*86048\***

Page 1

Item ID: D4062-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lower Tank Support

Start Date: 19/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MCS*

Date: *12/06/20* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4062	C								
100		0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER FILE D4062-3								
<i>U. item w. 800</i>	dwg rev: <i>E</i>								
	prog rev: <i>E</i>								
102	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*102*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

*4 0 JM 12-6-24*

*4 0 JM 12-6-24*

*4 n 12 06 25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86048**

June-19-12 4:11:02 PM

**\*86048\***

Page 2

Item ID: D4062-3

Revision ID:

Item Name: Lower Tank Support

Start Date: 19/06/2012 Start Qty: 4.00

Required Date: 03/07/2012 Req'd Qty: 4.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg & Stock Location: WA

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

d/x

SP  
12-6-25

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12/6/26  
nr  
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 4:11:05 PM

Page 1

Work Order ID: 86048

\*86048\*

Parent Item: D4062-3

\*D4062-3\*

Parent Item Name: Lower Tank Support

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-11-28 JLM VERIFIED BY:DD IPP  
REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB250

Purchased

No

sf

59.0000

11.36842

\*\*

\*MUHMWB250\*

SM 12-6-24

UHMWB .250 BLACK

Location

Loc Qty

Loc Code

MAT019

59

121064

59

121064

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 86048
<b>Description:</b> Lower Tank Support		<b>Part Number:</b> D4062-3
<b>Inspection Dwg:</b> D4062	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	0.994"	✓		V	mmol
2.00	+/-0.030	1.998"	✓		V	"
0.25	+/-0.030	0.253"	✓		V	"
2.95	+/-0.030	2.945"	✓		✓	"
4.95	+/-0.030	4.944"	✓		✓	"
10.07	+/-0.030				V	Producers
15.39	+/-0.030	15.39"	✓		mt	H301
20.71	+/-0.030	20.71"	✓		mt	H301
26.18	+/-0.030	26.18"	✓		mt	"
28.18	+/-0.030	28.18"	✓		mt	"
31.13	+/-0.030	31.13"	✓		mt	"
0.38	+/-0.030	0.379"	✓		✓	mmol
1.38	+/-0.030	1.376"	✓		✓	"
11.96	+/-0.030	11.895" 89"	✓		V	Producers
0.35	+/-0.030	0.355"	✓		V	mmol
6.31	+/-0.030	6.31"	✓		V	"
0.250	+/-0.010	0.248"	✓		V	"

<b>Measured by:</b> JM	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 12-6-24	<b>Date:</b> 12-06-25	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ [Signature]	[Signature]

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

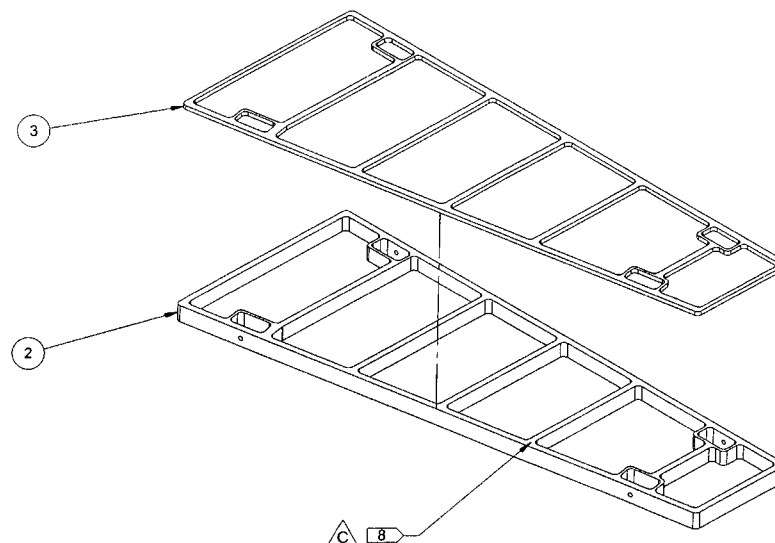
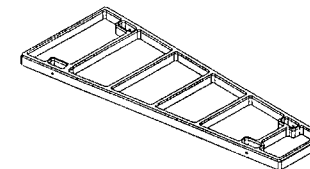
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**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



# **D4062-041 TANK SUPPORT ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 06048 MCT  
12/08/20

2012-03-02

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C'BORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.12.14		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4062</b>	REV. C
TITLE <b>TANK SUPPORT</b>	SHEET 1 OF 3
SCALE NTS	
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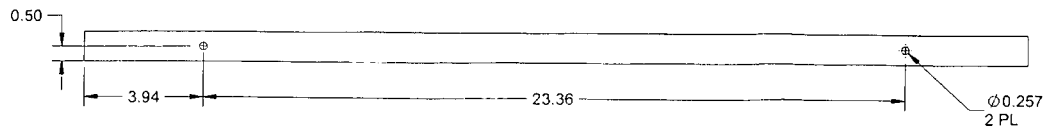
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

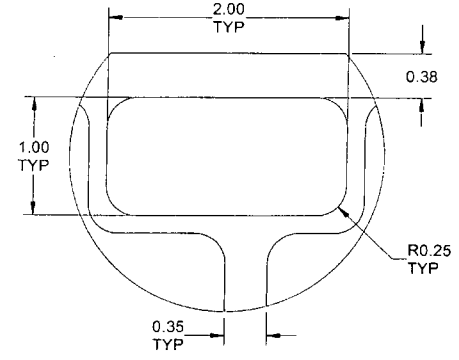
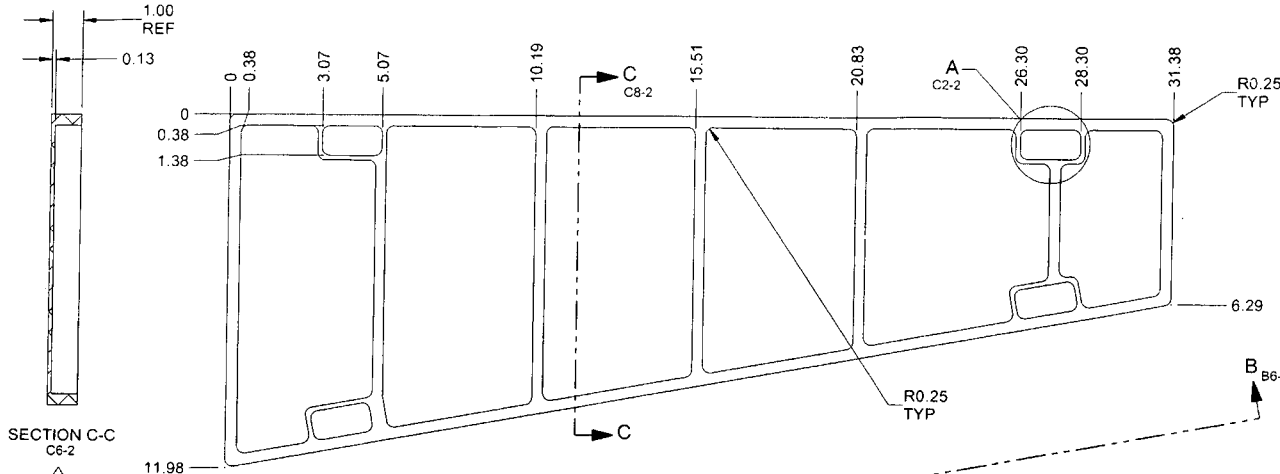
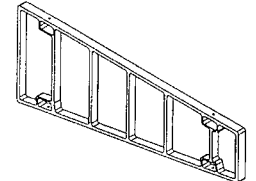
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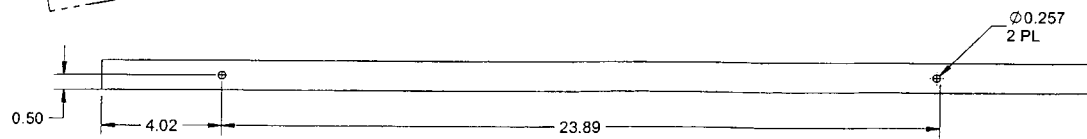
**NOTE:** Date & initial all entries



26048



**DETAIL A**  
**SCALE 4X**  
C4-2



**VIEW B-B**  
B5-2

**NOTES:**

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK  
REF DART SPEC MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs
- 8) CUT PER D4062-1.DXF
- 9) MAXIMUM INSIDE RADIUS = 0.250

**D4062-1 LOWER TANK SUPPORT**

DESIGN	BC	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4062	SHEET 2 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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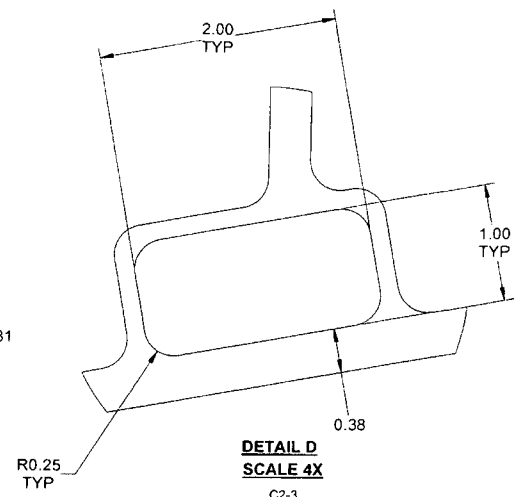
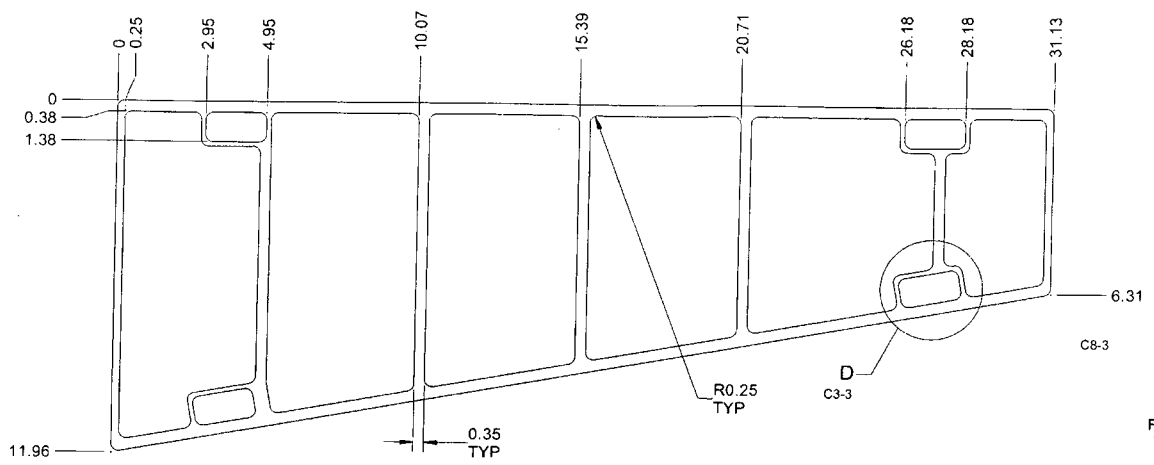
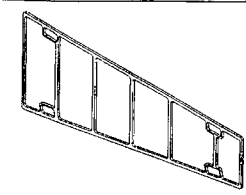
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86048



**D4062-3 UPPER TANK SUPPORT**

- NOTES:**
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK  
REF DART SPEC MUHMWB025
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.37 lbs
  - 8) CUT PER D4062-3.DXF

RELEASED  
2012-03-02

DESIGN	BC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO. <b>D4062</b>	REV. C
MFG. APPR.	BC	SHEET 3 OF 3	
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	<b>TANK SUPPORT</b>	NTS
DATE	11.12.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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